

Date: Wednesday, 1/18/2006 4:03:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW CAP
 Job Number : 25548
 Estimate Number : 10483
 P.O. Number : N/A Part Number : D3401041
 This Issue : 1/18/2006 S.O. No. : N/A Drawing Number : D3401 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 24887 Material : N/A
 Due Date : 1/30/2006 Qty: 10 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE DATE & USER
 Comment : Est. A 05.09.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R3500 Inventory



Comment: Qty.: 0.3675 f(s)/Unit Total : 3.6750 f(s)

Inventory

Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6R3.500)

Batch: M18745

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blanks

TSG06.01.2510

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA532 & Dwg D3401

Folio Rev: AADwg Rev: B

Deburr

J.F. / TSG06.01.2610

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / TSG06.01.2610

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: BFolio Rev: AA

Deburr & Buff rad as per Dwg D3401

Identify as D3401-1

M8 / J.G.06/01/2610

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:03:05 PM
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Drawing Name: TOW CAP

Job Number: 25548

Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 06.01.31 10

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink using DT8782 as per Dwg D3401

JB 06/02/02 (W)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-02

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/08 10

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ml 06 02 10 10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 02 21 10

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Insert

Pick:

Qty Part number Description Batch

4 NAS1330C3KB116 Insert

Assemble as per Dwg D3401

Identify as D3401-041

ml 06/04

FC 06 02 21 10

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 06 02 21 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:03:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW CAP

Job Number: 25548

Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR

FC 060221

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/02/22

(10)

ND 0602/22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

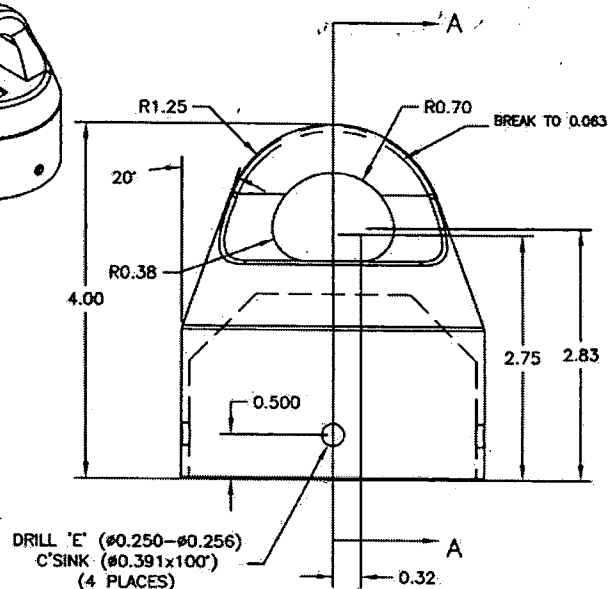
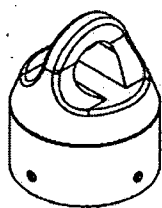
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

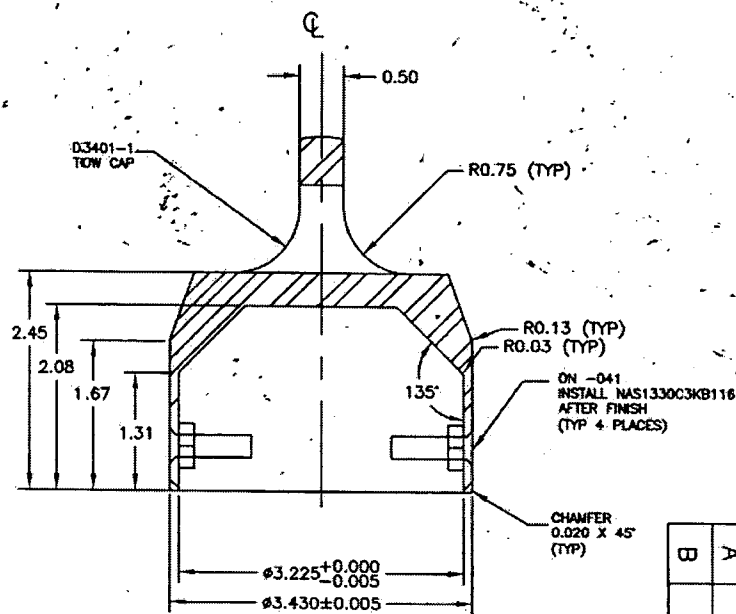
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



D3401-1 TOW CAP



SECTION A-A

D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 ϕ 3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
1	NAS1330C3KB116	INSERT

CONTROLLED COPY
NOT TO BE LOANED
WITHOUT NOTICE
WORK ORDER
NO. 25548

RELEASED
05-08-01

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, VA	REV. B
CHECKED		APPROVED		DRAWING NO.		SHEET 1 OF 1
DATE	05.06.09			TITLE	TOW CAP	SCALE
					NEW ISSUE	1:2
					CHAMFER INSIDE, REMOVE RADIUS	

